

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013704**Date Inspected:** 20-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Tian Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

**LAY DOWN YARD**

SEGMENT: 9EE-Panel Point (PP) #83~85. (Individual Survey by Caltrans)

This QA Inspector along with Caltrans QA Inspector Mr. Manikandan randomly performed Joint Inspection for the Deck panel to Deck panel diaphragm offset (plumbness) measured for SEGMENT: 9EE - from PP# 83~85. The measured readings were data recorded, generated the report and submitted to the Task Leader for further action.

This QA Inspector along with Caltrans QA Inspector Mr. Manikandan Randomly performed Joint Inspection for the Deck panel diaphragm flatness for the SEGMENT: 9EE - from PP#83~85. The flatness has been measured by using 710 mm length straight edge. The measured readings were data recorded, generated the report and submitted to the Task Leader for further action.

This QA Inspector along with Caltrans QA Inspector Mr. Manikandan performed joint Inspection for the Deck panel, Edge panel and side panel 'T' Rib cope holes dimension measured at Segment# 9EE - from PP#83~85 (Corner Assembly). The measured readings were data recorded, generated the report and submitted to

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the Task Leader for further action.

BAY: 5-Traveler Rail(TR).

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005552.

Visual Inspection (Dimensional survey).

This QA Inspector along with Caltrans QA Inspector Mr. Manikandan measured the length of Traveler Rails, Depth at typical section and sliding connection, web to flange offset, flange tilt, cut angle at sliding connection, flange width at typical section and sliding connection, thickness at typical and sliding connection..Total number of TR's:02 No's. The measured readings were data recorded, generated the report and submitted to the Task Leader . The TR designations are review as follows:

1. 10TR1-025.
2. 10TR3-019.

This QA Inspector Randomly observed the following work in progress:

BAY-1- TR

Flux Cored Arc Welding (FCAW) welding of weld joint 20TR2-019-009. Welder is identified as 215397. ZPMC Quality Control (QC) is identified as Mr. Xian Feng Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

FCAW welding of weld joint 20TR2-021-017. Welder is identified as 216575. ZPMC Quality Control (QC) is identified as Mr. Xian Feng Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Prabhu,Surendra

Quality Assurance Inspector

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**Reviewed By:** Hall,Steven

QA Reviewer